Date: ∬ser:

Thursday, 12/14/2006 3:46:33 PM

Kim Johnston

Process Sheet

Drawing Name

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 29980

: 10425

P.O. Number

First Issue

Written By

Previous Run

416:

: 29823

: 12/14/2006 This Issue Prsht Rev.

: NC : MA

S.O. No. : 7 4A

Type

: SMALL /MED FAB

Checked & Approved By

Comment

New issue KJ/JLM : Est. ESR B 06.05.25 Waterjet

: D32191 **Part Number**

: PLATE

: D3219 REV A **Drawing Number** : N/A

Project Number Drawing Revision Material

: 1/5/2007 **Due Date**

Qty:

40 Um: Each

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

M6061T6S125

6061-T6 .125 Sheet

Comment: Qty.:

0.1012 sf(s)/Unit Total: 4.0488 sf(s)

6061-T6 .125 Sheet

To be made in multiples of 4

Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Batch: M 18266

Description:

2.0 WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3219

Dwg Rev:

06 12 18

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

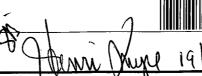
SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES						
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				L	.1	J	1		

Part No: _	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: 0 12/0
			QA: N/C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B			Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC inspecto		
						,				
						,				
				·				-		

NOTE: Date & initial all entries

Thursday, 12/14/2006 3:46:33 PM Date: Kim Johnston User: **Process Sheet Drawing Name: PLATE** Customer: CU-DAR001 Dart Helicopters Services Part Number: D32191 Job Number: 29980 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 574 FINAL INSPECTION/W/O RELEASE 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Ae	rospace	Ltd								
W/O:			W	ORK ORDER CHA	ANGES					
DATE	STEP	STEP PROC		ROCEDURE CHANGE		Ву	Date	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										:
Part No	•	PAR #:	Fault Cate	egory:	NCR:	Yes N	o DQA	۸:	_ Date:	
			-			QA: N/C	Closed	:	_ Date:	
NCR:		V	ORK ORD	ER NON-CONFO	RMANCE	(NCR)				
		Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descript Chief Eng	tion	Sign & Date	Section		Chief Eng	QC Inspector

	Description of NC		Collon B			Verification Approval		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
								,

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29980
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A	·	Page 1 of 1

	FIRST	ARTICLE IN	NSPECTI	ON CH	ECKLIST		
	X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Coi	mments
Ø0.316	+0.005/-0.000	0.316	/		vern		
2.293	+/-0.005	2.294	V		VerN		
2.965	+/-0.010	7.964	√		VerN		
0.566	+/-0.010	0.568	1		NOCH		
0.375	+/-0.010	0.314	1		Vern		
R0.125	+/-0.010	R0.125	1		VerN		
0.125	+/-0.010	0.125	7		Vern		
13.9	+/-0.010	13.9	Ĵ		Angle Meter	x -	
					\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		
				,			
	and and	A			Drototure A-	provoli	N/A
	M.MI	Audited by:	JX7		Prototype Ap	·	
Date: 0	B 12 18	Date:	06/12/1	٩		Date:	N/A

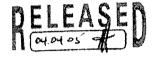
Measured by:	M.MI	Audited by:	Prototype Approval:	N/A
Date:	B 17 18	Date: Old 12/19	Date:	N/A
	0070	77/3/1		

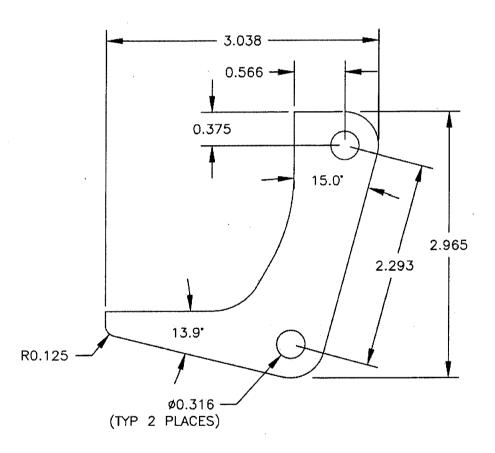
Rev	Date	Change	Revised by	Approv#d
Α	04.04.19	New Issue	KJ/JLM O	<i>\\\</i> []





DESIG	n	DRAWN BY	DART AEROS HAWKESBURY, ON	
CHEC	KED ,	APPROVED,	DRAWING NO.	REV. A
	#	M	D3219	SHEET 1 OF 1
DATE			TITLE	SCALE
03.1	10.10		PLATE	1:1
Α		03.10.10	NEW ISSUE	





D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)

(REF DART SPEC M6061T6S.125)

- 3) FINISH: NONE
- BREAK ALL SHARP EDGES 0.005 TO 0.015
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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